

Date: Wednesday, 10/3/2007 8:39:31 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT ASSEMBLY
Job Number : 34989	
Estimate Number : 11248	
P.O. Number :	Part Number : D3438042
This Issue : 10/3/2007 S.O. No. :	Drawing Number : D3438 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 32596	Material :
Written By :	Due Date : 10/30/2007 Qty: 2 Um: Each
Checked & Approved By : <u>07 10 03</u>	
Comment : Est A 05.05.18 New Issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D267334	End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2673-34	End Cap	<u>332404</u>

07-10-17 2

2.0	D2561	Lug Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2561	Lug Plate	<u>332403</u>

07-10-17 2

3.0	D2564	Mounting Angle
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part No.	Description	Batch
2	D2564	Mounting Angle	<u>332460</u>

07-10-17 2

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 79.63" at 34° as per Dwg D3438

2-Deburr ends

3-Weld one cap, LUG PLATES & MOUNTING ANGLE as per Dwg D3438 using DT8343

07-10-17 2
07-10-17 2
07-10-17 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description:

4-Grind

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-22 2
07/10/23 (2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/23 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAO 07-10-23 (2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

2X
M-1 07/10/23

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last cap per dwg D3438 & grind flush

07-11-16 2

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-11-29 (2)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-11-19 (2)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Touch up alodine

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07-11-20 (2)
M105914 BR 07-11-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:.		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Job Number: 34989

Part Number: D3438042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



m106060



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg 3438 and QSI 005 4.4

Mask off 0.5 each side of D2561 lugs

FL 07/11/20 (2)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LC 7/4/28

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PAP

35870

LC 7/4/28 E

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.28

Job Completion



LC 07.11.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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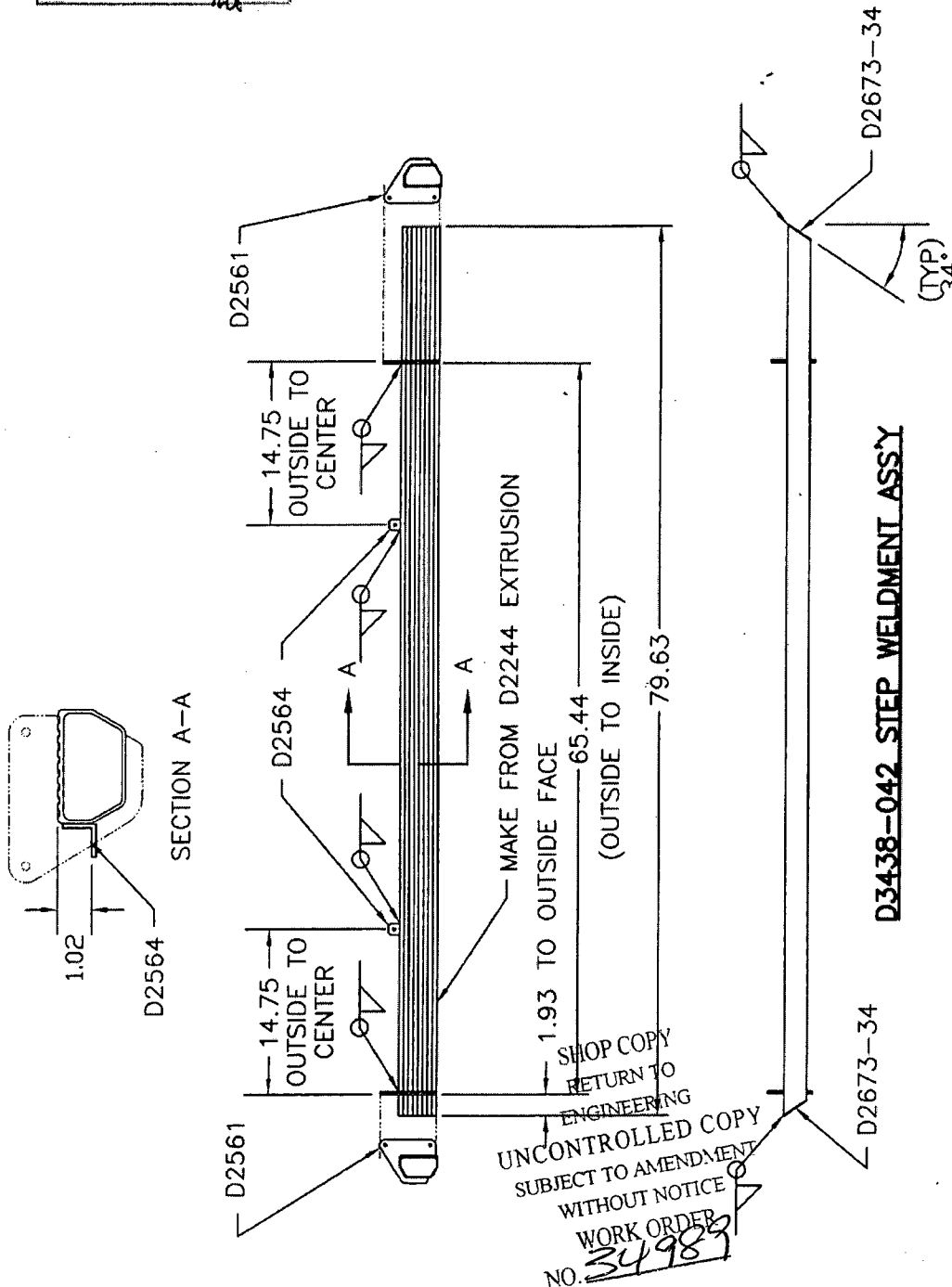
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3438	REV. A SHEET 1 OF 1
DATE 05.05.09		TITLE STEP WELDMENT ASSEMBLY	SCALE 1:1
A	05.05.09	NEW ISSUE	

RELEASED

05.05.27

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1
WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

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